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D4165-7**Job Sheet 190768****Part No:** D4165-7**Job Qty:** 6 pcs**Part Name:** Fwd Rib**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/14/19**Job Tracking No:****Due Date:** 3/22/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:** SIOP**Note:** DWG REV B SHEET 4 IPP Rev:A 11.03.09 new issue DD verf:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		3/22/19	0.00	0.49	Waterjet - Flow		DAS 69 7/3/19 9-89
120	QC 8	6 pcs		3/22/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		DAS 40 JUL 03 2019 9-89
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
130	Handfinish - 1-1 Chemical-B4B	6 pcs		3/22/19	0.00	0.46	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		

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					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
135 QC 7	6 pcs	3/22/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
140 Packaging 3-1 - Stock - B4B	6 pcs	3/22/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	

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JUL 04 2019 40
9-89

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST 236
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
150 QC 21 - SA	6	3/22/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21 JUL 05 2019
				QC 21 - SA - 53	9-89

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)QC8- Inspect parts - second check
 130 - (Chemical Conversion Coat per QSI005 4.1) Chemical Conversion Coat per QSI005 4.1
 135 - (QC7-Inspect Chemical Conversion Coat)QC7-Inspect Chemical Conversion Coat
 140 - (Identify as per dwg & Stock Location:) Identify as per dwg & Stock Location:
 150 - (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	4.0800 sf (.68 ea)	100-Waterjet - Flow - 1	5153359

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	4	96	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Rib	2.000Inches + 0.012 - 0.001	2.012 1.999	1.999 Diameter	
2	Fwd Rib	6.370Inches ± 0.030	6.400 6.340		
3	Fwd Rib	3.220Inches ± 0.030	3.250 3.190		
4	Fwd Rib	11.380Inches ± 0.030	11.410 11.350		
5	Fwd Rib	15.460Inches ± 0.030	15.490 15.430		
6	Fwd Rib	3.260Inches ± 0.030	3.290 3.230		
7	Fwd Rib	4.920Inches ± 0.030	4.950 4.890		
8	Fwd Rib	0.040Inches ± 0.010	0.050 0.030		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S195352



Part: D4165-7

Job No: 190768

Serial No/Batch: S195352

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/03/19